Friday, 28/11/2008 2:53:36 PM

User:

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 43838

Estimate Number

: 10822

P.O. Number

Prsht Rev.

First Issue

This Issue

: 28/11/2008 : NC

: //

: 42099

Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D2274

Drawing Number

: D2274 REV F

: RADIUS BLOCK

Project Number

: N/A : F

Drawing Revision Material

Due Date

: 20/12/2008

Qty:

500 Um:

Each

Previous Run Written By

Checked & Approved By

Comment

: Est. H 00.05.18

Added inspection level 8

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

6061-T6 Bar .750 x .125

EC

M6061T6B0750X00125

Comment: Qty.:

0.0962 f(s)/Unit

Total: 48.0900 f(s)

6061-T6 Bar .75" x .125"

SHEAR

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M109740

2.0

Comment: SHEAR

Shear blanks 9.00" long +/- 0.030"

Note: 1 blank makes 9 pieces

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC2

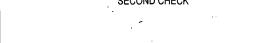


Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



· Comment: SECOND CHECK



W/O:		Ltd	W	ORK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHA	INGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
м.									
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	_ Date: _	
	Res	solution:	Dispositio	n:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	ICE (NCR				
		Description of NO	Corrective Action Section		В	Varifies	Verification		Approva
DATE	STEP	Description of NC Section A	Ínitial	Action Description	Sign &	Section C			QC Inspect
			Chief Eng	Chief Eng	Date				<u> </u>
			Chief Eng	Cnier Eng	Date				
			Chief Eng	Cnier Eng	Date	4		·	
			Chief Eng	Cnier Eng	Date				
			Chief Eng	Cnier Eng	Date				
			Chief Eng	Cnier Eng	Date				
			Chief Eng	Chief Eng	Date				

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 2:53:36 PM Úser: -Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: RADIUS BLOCK Job Number: 43838 Part Number: D2274 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble 188-13-65 Deburr any rough edges after tumbling . HAND FINISHING1 7.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: W 08/12/16 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

	. oopaoo								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ A	\:	Date:	
	Re	solution:	Disposition	Disposition:			QA: N/C Closed:		
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR)			• .
		Description of NC		Corrective Action Section	i VARIT		ication Approval	Approval	
DAIE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sign & Section C			QC Inspector
				•					
		·		,					
					1			1	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 43838
Description: Radius Block	Part Number: D2274
Inspection Dwg: D2274 Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.260	~	_		
0.750	+/-0.010	0.749	~			
0.375	+/-0.010	0.373	V			
0.125	+/-0.010	0.126	V		7	
0.750	+/-0.010	0.752	/			
0.063	+/-0.010	0.064	1			
			-			
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		,				
			-			
1			1		T	· · · · · · · · · · · · · · · · · · ·

Measured by: \$\mathcal{H}. A	Audited by: Onl	Prototype Approval:	N/A
Date: 08/12/04	Date: 08/12/11	Date:	N/A

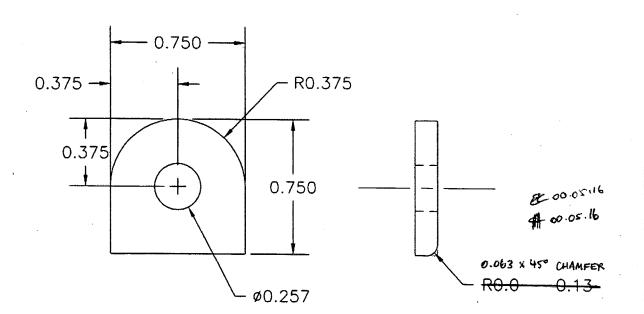
Rev	Date	Change	Revised,by	Approved
A	03.10.07	New Issue	KJ/RF	4





	Coccio			
	DESIG	r F	DRAWN BY	DART AEROSPACE LTD
		ne	17	HAWKESBURY, ONTARIO, CANADA
	CHEC	SD & Y	APPROVED	DRAWING NO. REV. F
•		N W	143	D2274 SHEET 1 OF 1
	DATE			TITLE SCALE
	98.0	08.11		RADIUS BLOCK 2:1
	Α		94.09.29	NEW ISSUE
	С		95.07.12	RADIUS ENDS
	D		97.03.24	ADD MATERIAL SPECIFICATION
	Ε		97.12.12	ADD FINISH & TOLERANCE QSI
	F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125

RELEASED 18 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK

OR 6061-T6 (QQ-A-250/11) 0.125 THICK NO. 43838

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED